

Work Order ID 135228

August 06, 2015 3:27:32 PM

135228

Page 1

Orders to ship Aug 21 + or sooner.

Item ID: D206-628-021

Accept

N900040100

Setup Start

NS1

Aug 14th

Revision ID:

Stop

NS2

Item Name: Heli-Access-Step™ LH - High Gear 206L/L1/L3/L4

Start Date: 8/5/2015 Start Qty: 3.00

3

Cust Item ID:

Required Date: 8/14/2015 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: *SH* **20150806** Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D206-628	G

JA

SH 15-08-07

100 Document Control 0.00
DOCUMENT CONTROL

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy blue file and type labels as per PPP D206-628-021 CHG 003

(3)

DAS
38
9-89

15-08-19

110 Pick Kit 0.00

110

Packaging

Memo

0.00

Packaging

(3) JA

STU 7 0 511V
AUG 07 2015

120 QC4- 100% Inspect kits for completeness 0.00

120

QC

Memo

0.00

Quality Control

1

DAS
38
9-89

15-08-20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			

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Item ID: D206-628-021

Accept

N1900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ LH - High Gear 206L/L1/L3/L4

Start Date: 8/5/2015 Start Qty: 3.00 ***3***

Cust Item ID:

Required Date: 8/14/2015 Req'd Qty: 3.00 ***3***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-628-021
Location : FG081DAS 3
6
9-89

AUG 21 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.01

Quality Control

MCS

AUG 21 2015

MF
15-8-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Picklist Print

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Work Order ID: 135228

135228

Parent Item: D206-628-021

D206-628-021

Parent Item Name: Heli-Access-Step™ LH - High Gear 206L/L1/L3/L4

Start Date: 8/5/2015

Required Date: 8/14/2015

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP Rev:D as per ECN 766 JLM
 IPP Rev:E as per ecn 1118 DD verified by:EC
 11.09.15 added NAS1149D0463J DD verf by:EC
 IPP Rev:F

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-14A		Purchased	No			120	Each	211.0000	4	12			
AN4-14A									**	JA			
Bolt	DAS 38 9-89												
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				5					
				122141				5					
				ST325A				100					
				M132677				100					
				ST344				106					
				M132640				106		12			
AN4-15A		Purchased	No			120	Each	275.0000	8	24			
AN4-15A									**	JA		AUG 07 2015	
Bolt	DAS 38 9-89												
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				40					
				120449				40					
				ST325A				235					
				m128978				8					
				m132317				27		24			
				m132551				200					
D2724-041		Manufactured	No			120	Each	0.0000	1	3			
D2724-041									**	135241			
206L Step Assembly, LH	DAS 38 9-89												

w/o made for these.
 135241

Picklist Print

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Work Order ID: 135228

135228

Parent Item: D206-628-021

D206-628-021

Parent Item Name: Heli-Access-Step™ LH - High Gear 206L/L1/L3/L4

Start Date: 8/5/2015

Required Date: 8/14/2015

Start Qty: 3.00

Required Qty: 3.00

D2731-7 Manufactured No 120 Each 38.0000 4 12

D2731-7

Mounting Lug

DAS
38
9-89

**

JA

Location

Loc Qty

Loc Code

ST520

38

132234

14

132444

24

12

D2732-030

Manufactured No

120 Each

80.0000

8

24

D2732-030

Rubber Cushion - 3"

DAS
38
9-89

**

JA

Location

Loc Qty

Loc Code

FG

34

134608

34

ST410

46

133074

46

D3394-043

Manufactured No

120 Each

72.0000

4

24 12

D3394-043

Lug

DAS
38
9-89

**

JA

AUG 07 2015

Location

Loc Qty

Loc Code

ST528

72

131774

16

132499

26

134677

30

12

Picklist Print

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Page 3

Work Order ID: 135228

135228

Parent Item: D206-628-021

D206-628-021

Parent Item Name: Heli-Access-Step™ LH - High Gear 206L/L1/L3/L4

Start Date: 8/5/2015

Required Date: 8/14/2015

Start Qty: 3.00

Required Qty: 3.00

MS21042L4

Purchased

No

120

Each

2,928.000

12

36

MS21042L 4

Locknut

DAS
38
9-89

**

JA

AUG 07 2015

DAS
6
9-89

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

134

m127813

134

ST260a

170

m130799

56

m131803

6

m132262

108

ST305

2622

m128300

8

m128798

12

m130388

7

m130922

97

m131618

12

m132123

56

m132382

2430

36

Picklist Print

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Work Order ID: 135228

135228

Parent Item: D206-628-021

D206-628-021

Parent Item Name: Heli-Access-Step™ LH - High Gear 206L/L1/L3/L4

Start Date: 8/5/2015

Required Date: 8/14/2015

Start Qty: 3.00

Required Qty: 3.00

NAS1149D0463J

Purchased

No

120

Each

3,314.000

12

36

NAS1149D0463.J

WASHER

JA

AUG 07 2015

DAS
6
9-89

DAS
38
9-89

Location

Loc Qty

Loc Code

GA	41	
M129390	41	
ST260a	1000	
M132677	1000	
ST269	2273	
M127904	20	
M129682	86	
M130799	371	
M132035	1671	
M132317	125	

36

5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS- STEPS™ PARTS LIST

Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
				4	4	D2731-3	MOUNTING LUG
4	4	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
				4	4	D3394-041	MOUNTING LUG
				4	4	*D3394-1	*MOUNTING LUG
				8	8	*MS35489-93	*GROMMET
4	4	4	4			D3394-043	MOUNTING LUG
4	4	4	4			*D3394-3	*MOUNTING LUG
8	8	8	8			*MS35489-93	*GROMMET
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
4	4	8	8	4	4	AN4-15A	BOLT
12	12	12	12	12	12	NAS1149D0463J	WASHER (AN960JD416)
12	12	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE